

Work Order ID 68350

Tuesday, April 12, 2011 10:08:51 AM



Page 1

Item ID:	D3564-11	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	4/12/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	4/15/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3564	Rev D								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 ***** (D3564-1F) ***** <input type="checkbox"/> Dwg Rev: <u>D</u> <input type="checkbox"/> Prog								
364 . 063	Rev: <u>D</u> <input type="checkbox"/> 2-Deburr if necessary								

811-4-14

13

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

181-4-14

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11 04 14 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

Sub 4/12/11



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

Sub 4/12/11



QC

Memo

0.00

Quality Control

(43)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 115 128



Powdercoat

Memo

0.00

Powder Coating

START TIME:

3:10

OVEN TEMPERATURE:

3:00 FINISH TIME:

3:40

13 BR 11-4-27

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Page 4

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Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 *MF* 11 04 27

200

Identify as per dwg & Stock Location: *FD-19* 0.00

Packaging

Memo

0.00

Packaging

13 *BL* 11-4-27

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*n14/289**MF*
11 04-27

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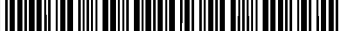

NOTE: Date & initial all entries

Tuesday, April 12, 2011 10:08:57 AM

**Required Date:** 4/15/2011

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	241.0000	1.41	17.81053			
 													
304/316 Sheet .063													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				241					
				117275				241		117275			(13)

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	68350
Description: Wearshoe		Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	✓		U HBZ	
2.432	+/-0.010	2.440	✓		U	
2.50	+/-0.030	2.500	✓		U	
6.000	+/-0.010	6.000	✓		T HB01	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.000	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	301 x 303	✓		U	
Ø0.188	+0.005/-0.001	189 301 x 303	✓		U	
R0.375	+/-0.010	375	✓		R. G	
0.063	+/-0.010	0.057	✓		U	

Measured by: AB	Audited by: M. M.	Prototype Approval:	N/A
Date: 11-4-14	Date: 11-04-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

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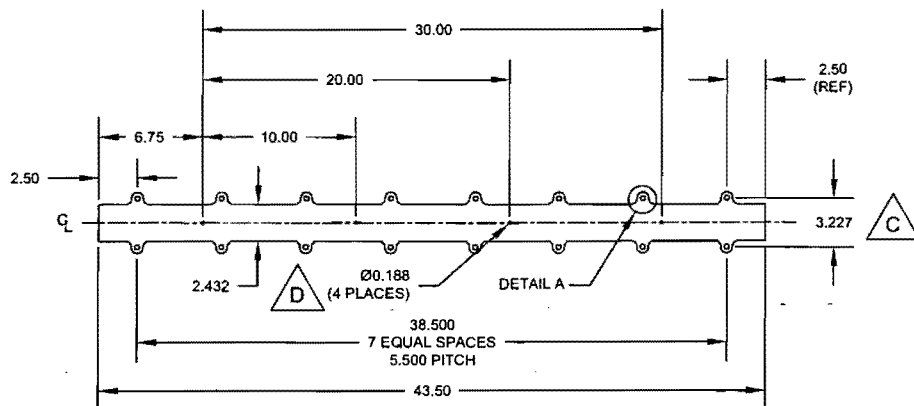
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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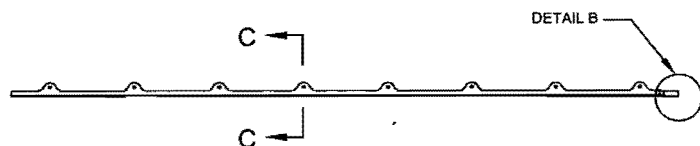
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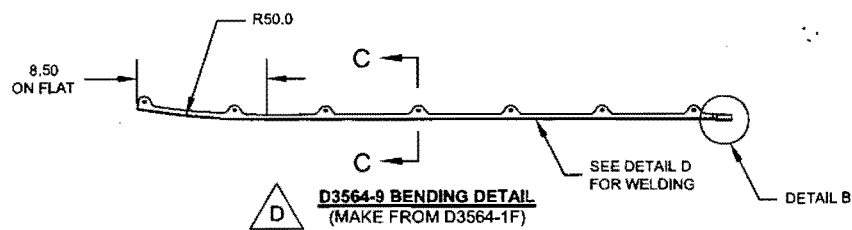
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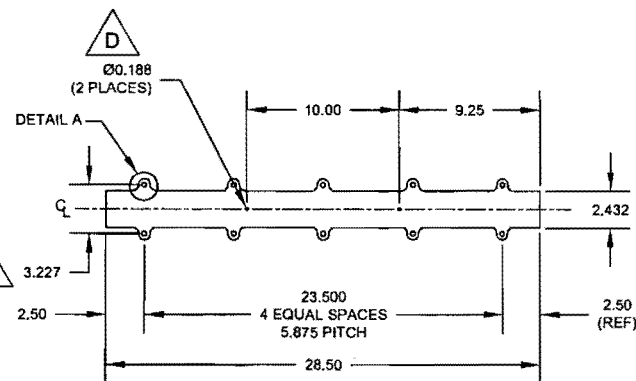
D3564-5F FLAT PATTERN



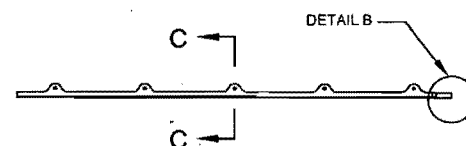
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



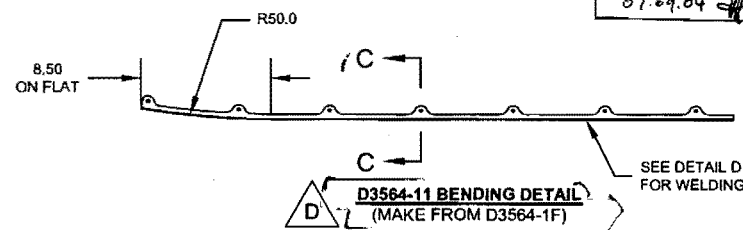
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48350

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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PH 11-04-12

8 7 6 5 4 3 2 1

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